



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G13831-3G

Job Sheet 187387



006930

Part No: RBW6205G13831-3G

Job Qty: 1 ea

Part Name: AW139 Swashplate Box 2



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/3/18

Job Tracking No:

Due Date: 12/4/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBW6205G13831-3G REV 2 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/4/18	12/4/18	0.00	0.00	Start Up Small Fab-4		7/10/20 DAS
110	Small Fab	1 pcs	12/4/18	12/4/18	0.00	1.00	Small Fab-4		38
120	QC	1 pcs	12/4/18	12/4/18	0.00	0.00	QC5		9-89
130	Packaging	1 pcs	12/4/18	12/4/18	0.00	0.00	Packaging3-1		21 DEC 04 2018
140	QC21-FG	1 Ea	12/4/18	12/4/18	0.00	0.00	QC21		

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1600-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6205G13831-3G-9 to RBW6205G13831-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
40 97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	5113449
28 3777T12	Spring Catch	2 Ea (2 ea)	110-Small Fab	5120484
128B APP-1600-E	Case	1 Ea (1 ea)	110-Small Fab	5124789
135A RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	5021040
138 RBW6205G12731-3G	Upper Plate Assembly	1 Ea (1 ea)	110-Small Fab	5079012
146B RBW6205G13151-3G	Lower Plate	1 Ea (1 ea)	110-Small Fab	5067146
095 RBW6205G13231-3G	Arm Assembly	3 Ea (3 ea)	110-Small Fab	5078998
128B RBW6205G13531-3G	Screw Assembly	1 Ea (1 ea)	110-Small Fab	5065517
181 RBW6205G13831-3G-1	Shelf Backing	1 Ea (1 ea)	110-Small Fab	5124793
128B RBW6205G13831-3G-11	Dynamometer	1 pcs (1 ea)	110-Small Fab	5133528
128B RBW6205G13831-3G-3	Shelf	1 Ea (1 ea)	110-Small Fab	5124792
128B RBW6205G13831-3G-5	Bottom Foam use in case APP-1600-E	1 Ea (1 ea)	110-Small Fab	5124791
128B RBW6205G13831-3G-7	Lid Foam use in case APP-1600-E	1 Ea (1 ea)	110-Small Fab	5124790
RBW6205G13831-3G-9	Location Placard	1 Ea (1 ea)	110-Small Fab	5134288

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	647	0
110-Small Fab	3777T12	2	8	0
	APP-1600-E	1	9	0
	RB41011	1	681	0
	RBW6205G12731-3G	1	1	0
	RBW6205G13151-3G	1	5	0
	RBW6205G13231-3G	3	3	0
	RBW6205G13531-3G	1	1	0
	RBW6205G13831-3G-1	1	4	0
	RBW6205G13831-3G-11	1	6	0
	RBW6205G13831-3G-3	1	4	0
	RBW6205G13831-3G-5	1	6	0
	RBW6205G13831-3G-7	1	6	0
	RBW6205G13831-3G-9	1	0	0
Part Specifications				
Specifications could not be found.				

Plex 12/3/18 1:40 PM dart.lacelle.linda

DART
AEROSPACE

Container No: S134105



Part: RBW6205G13831-3G

Job No: 187387

Serial No/Batch: S134105

Revision: 2

Inspector:

Exp Date:

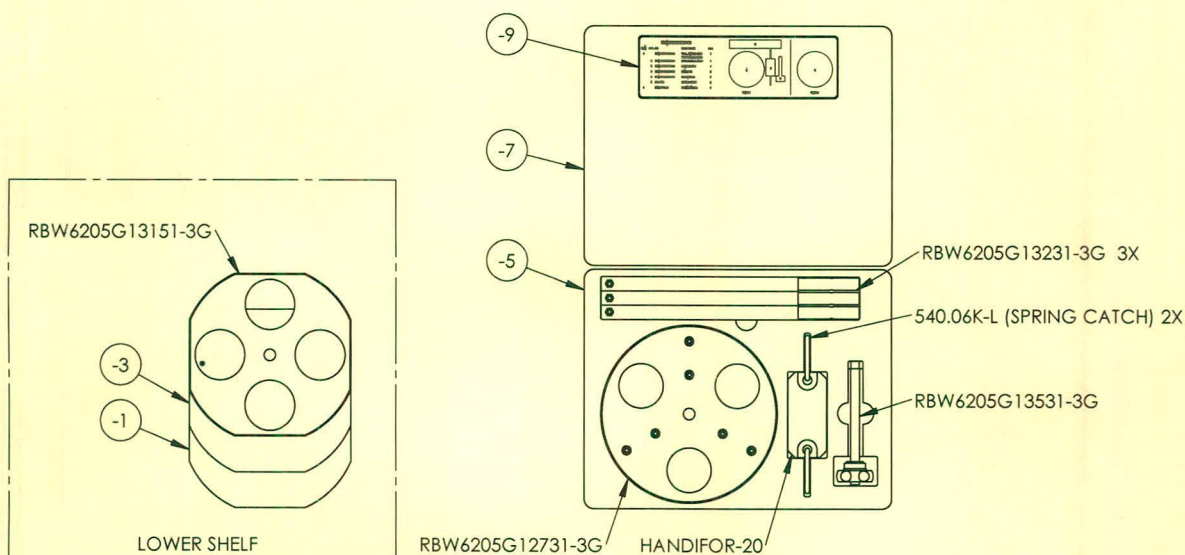
Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/03/18

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 & -3 ADDED NOTE -5 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER, -7 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER, CH'D CUTOUT TO RECESSED POCKET ADDED CUTOUT ON BOTTOM FOR CASE PIN CLEARANCES AND MATERIAL FROM C200 FLAT TO 1780 FLAT BLACK.	6/29/2011	RJC	RW
2	15-0151	-5 CH'D CUTOUT SIZE AND DEPTH FOR -11 & -13. CH'D DIM WAS $\nabla 1.00$ IS $\nabla 1.60$ FOR RBW6205G13231-3G. -7 CH'D FOAM WAS 1780 FLAT, BLACK IS Y20 BLACK, CH'D CUTOUT DEPTH FOR PLACARD WAS .063 IS .13. -9 REMOVED TEXT "CONTENT LIST", CH'D DESCRIPTION WAS PLACARD IS	7/8/2015	RJC	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	UPPER PLATE ASSEMBLY		RBW6205G12731-3G	1
				1	LOWER PLATE		RBW6205G13151-3G	1
				3	ARM ASSEMBLY		RBW6205G13231-3G	1
				1	SCREW ASSEMBLY		RBW6205G13531-3G	1
	B/O	-1	1	1	SHELF BACKING	COROPLAST	BLACK, 6mm Ø12-7/16 I.R. SPECIALTY	2
	B/O	-3	1	1	SHELF	Y20 BLACK	Ø12-7/16 X 13/16	3
	B/O	-5	1	1	BOTTOM FOAM	Y20 BLACK	6-1/8 X 16-3/4 X 21-3/4 I.R. SPECIALTY	4
	B/O	-7	1	1	LID FOAM	Y20 BLACK	1-3/4 X 16-3/8 X 21-5/16 I.R. SPECIALTY	5
		-9	1	1	LOCATION PLACARD	PLASTIC		6
	B/O	-11	1	1	DYNAMOMETER		HANDIFOR-20	1
	B/O	-13	2	2	SPRING CATCH	S.S.	Ø5/16 CARABINER STYLE (MCMaster-CARR #3777112)	1
	B/O	-15	1	1	CASE	PLASTIC, BLACK	8 X 17 X 22 PELICAN #APP-1600-E	N/S
	B/O	-17	1	1	DART PLACARD	ALUMINUM	#RB41011	N/S

NOTE:
PART OF KIT RBW6205G11231-3G.

DART AEROSPACE	
TITLE AW139 SWASHPLATE KIT	
DWG NO. RBW6205G13831-3G	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 6° .X ± .1 1. BREAK ALL SHARP EDGES .016 x 45° OR .016 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: CLOUGH APPROVED <i>D. Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AW139
SCALE 1:10	DATE 1/31/2011 SHEET 1 OF 6

